

# Work Order ID 64557

Wednesday, December 08, 2010 10:24:43 A



Page 1

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 12/8/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date:

*10-12-8*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2662

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

Program part number and batch number. ☐ Inspect part number and batch number are programmed correctly. ☐ Fixturing Inspection last completed 64557 by B.A. ☐ Machine Step No 1 of Folio and inspect per attached Dimension Sheet ☐ Machine Step No 2 of Folio

0.00

*B.A 11/09/21*

*8*

*φ*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Conventional Milling Machine

Memo

Machine Keyway and inspect per attached dimension sheet

0.00

*B.A 11/09/22*

*8*

*φ*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

*B.A 11/09/21*

*8*

*φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Wednesday, December 08, 2010 10:24:43 A



Page 2

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Setup Start



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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

*Handwritten: 11/23*



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*Handwritten: 8 of 11/09/26*

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

*Handwritten: 8:40*

*Handwritten: 3200F*

*Handwritten: 9:10*

*Handwritten: 8x of 11/09/28*

*Handwritten: M 11 8434*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64557**

Wednesday, December 08, 2010 10:24:43 A



Page 3

Item ID: D2662-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH In 206

Start Date: 12/8/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				8	6	20	11/05/25
						control			
170  Packaging Packaging	Identify as per dwg & Stock Location: ST 435  Memo	0.00  0.00							
									SL 8P (8X) 11-09-28
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							
									11/10/03 JF MF 11-09-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, December 08, 2010 10:24:47 AM

Page 1

Work Order ID: 64557

Parent Item: D2662-1

Parent Item Name: Saddle, LH In 206




Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.06.22 Removed P/O for powder coat EC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	8.0000	1	8			

Saddle Billet

Location

Loc Qty

Loc Code

MAT40

8

61385

2

63537

6

*69677*

73768

*PA*  
10.0

B.A 11/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2662-1
<b>Inspection Dwg:</b> D2662 Rev. D	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.115	0.115	0.115	0.114	Mrc	GA-03
B	0.100	0.140		0.125	0.128	0.138	0.138	Mrc	118-120
C	1.125	1.145		1.1406	1.141	1.1408	1.1395	Dal	HAAS7
D	0.615	0.685		0.683	0.683	0.683	0.683	Vern	GA-01
E	0.240	0.260		0.250	0.244	0.245	0.246	"	"
F	1.313	1.343		1.324	1.323	1.323	1.323	H-6	31006
G	0.210	0.230		0.221	0.221	0.221	0.221	Vern	GA-01
H	0.100	0.180		0.135	0.135	0.135	0.135	"	"
I	2.470	2.510		2.490	2.490	2.490	2.490	"	"
J	1.565	1.585		1.582	1.582	1.581	1.579	Dal	HAAS7
K	0.235	0.240		0.238	0.238	0.238	0.238	Vern	GA-01
L	0.100	0.120		0.110	0.110	0.110	0.110	"	"
M	0.990	1.010		0.992	0.992	0.992	0.992	"	"
N	0.510	0.515		0.514	0.514	0.514	0.514	"	"
O	5.990	6.010		6.000	6.000	6.000	6.000	"	"
P	1.245	1.255		1.250	1.250	1.250	1.250	"	"
Q	2.495	2.505		2.500	2.500	2.500	2.500	"	"
R	0.313	0.318		0.315	0.315	0.315	0.315	"	"
S	0.315	0.322		0.317	0.317	0.317	0.317	"	"
T	2.495	2.505		2.500	2.500	2.500	2.500	"	"
U	1.357	1.367		1.362	1.362	1.362	1.362	"	"
V	0.787	0.807		0.797	0.797	0.797	0.797	"	"
W	0.540	0.560		0.550	0.550	0.551	0.550	"	"
X	1.674	1.684		1.679	1.679	1.679	1.679	"	"
Y	0.257	0.262		0.259	0.259	0.259	0.259	"	"
Z	0.912	0.932		0.922	0.922	0.922	0.922	"	"
AA	0.490	0.510		0.503	0.502	0.501	0.501	"	"
AB	0.178	0.198		0.188	0.188	0.188	0.188	R-6	R-6 ref
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	Ba
Date:	11/09/22

Audited by:	
Date:	11/9/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	64559
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2662-1
<b>Inspection Dwg:</b> D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.100	0.140		0.115	0.114	0.116	0.115	Mic	GA-03
B	0.100	0.140		0.135	0.137	0.136	0.135	Mic	118-120
C	1.125	1.145		1.140	1.138	1.140	1.140	Dial	HAASZ
D	0.615	0.685		0.683	0.683	0.683	0.683	Vern	GA-01
E	0.240	0.260		0.245	0.247	0.248	0.248	"	"
F	1.313	1.343		1.324	1.324	1.323	1.324	H-6	31006
G	0.210	0.230		0.221	0.221	0.221	0.221	Vern	GA-01
H	0.100	0.180		0.135	0.135	0.135	0.135	"	"
I	2.470	2.510		2.490	2.490	2.490	2.490	"	"
J	1.565	1.585		1.580	1.578	1.581	1.582	Dial	HAASZ
K	0.235	0.240		0.238	0.238	0.238	0.238	Vern	GA-01
L	0.100	0.120		0.110	0.110	0.110	0.110	"	"
M	0.990	1.010		0.992	0.992	0.992	0.992	"	"
N	0.510	0.515		0.514	0.514	0.514	0.514	"	"
O	5.990	6.010		6.000	6.000	6.000	6.000	"	"
P	1.245	1.255		1.250	1.250	1.250	1.250	"	"
Q	2.495	2.505		2.500	2.500	2.500	2.500	"	"
R	0.313	0.318		0.315	0.315	0.315	0.315	"	"
S	0.315	0.322		0.317	0.317	0.317	0.317	"	"
T	2.495	2.505		2.500	2.500	2.500	2.500	"	"
U	1.357	1.367		1.362	1.362	1.362	1.362	"	"
V	0.787	0.807		0.797	0.797	0.797	0.797	"	"
W	0.540	0.560		0.550	0.551	0.550	0.548	"	"
X	1.674	1.684		1.679	1.679	1.679	1.679	"	"
Y	0.257	0.262		0.259	0.259	0.259	0.259	"	"
Z	0.912	0.932		0.922	0.922	0.922	0.922	"	"
AA	0.490	0.510		0.501	0.501	0.500	0.501	"	"
AB	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	HA
Date:	11/09/22

Audited by:	SA
Date:	11/9/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.1.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**DART**

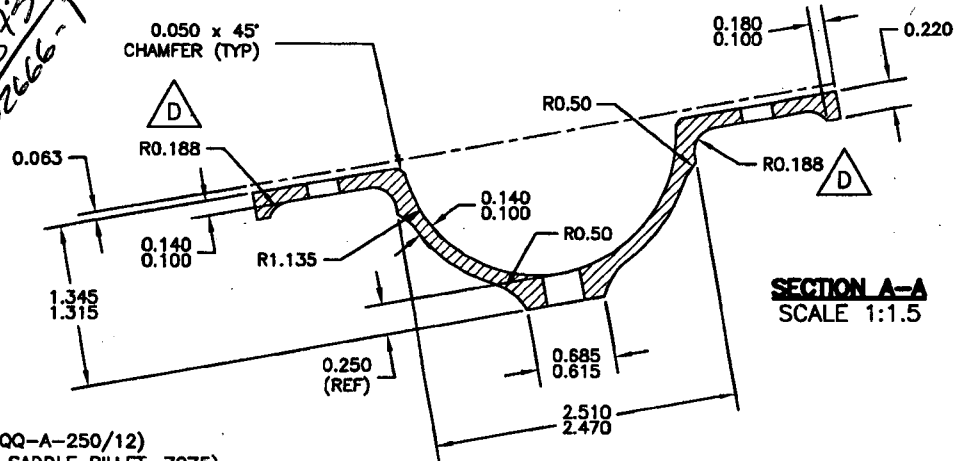
4.125 4608

RELEASED 07.02.12

DT8731  
D2662-1

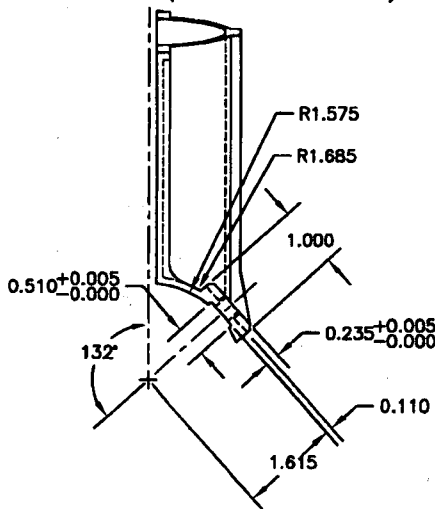
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44557  
p1012-1

DESIGN	<i>PH</i>	DRAWN BY	CB	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO.	REV. D
				D2662	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE INSIDE	1:3
A	97.03.25	NEW ISSUE			
B	97.07.11	ANGLE AND NOTES ADDED			
C	06.05.29	INCORP' DEO 9122/9102/9095/9137			
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$			

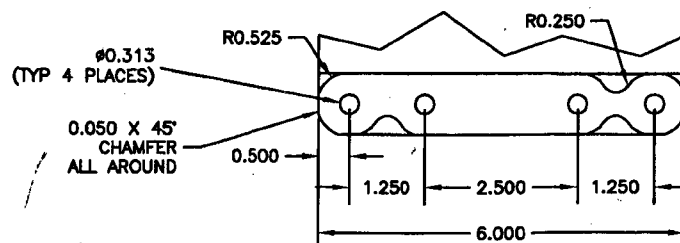
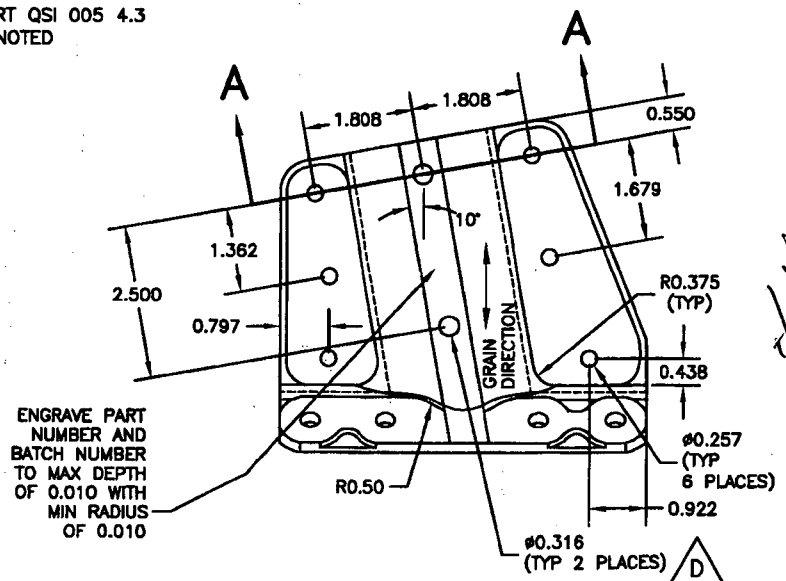


**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)



**D2662-1 SADDLE INSIDE**



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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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